

Work Order ID 57247

March 31, 2010 10:03:02 AM



Page 1

Item ID: D5957

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 31/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-3-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5957	Rev B								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5957, Ensure Batch Number is entered
2-Machine Keyway
3-Deburr & Tumble

pl 10.4.5
M.A 10/04/06

4 1

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

M.A 10/04/06

4 1

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

M.A 10/04/07

4 1

PTO →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Machined NCR: (Yes) No DQA: ls Date: 10.04.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>57247</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/06</u>	<u>100</u>	<u>1 part have a big notch .350 deep in exterior bore Saddle was placed incorrectly. Dowel pins in 2nd hole instead of 3rd. RC. Operator error LOA.</u>	<u>[Signature]</u> <u>LSB42</u>	<u>Scrap: replace Qty 1</u>	<u>B.A</u> <u>10/04/06</u>	<u>and</u> <u>10/04/07</u>	<u>[Signature]</u> <u>LSB42</u>	<u>[Signature]</u> <u>10.04.07</u>

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 10/04/08

X4

Ø



HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=> M 10/04/08

(X4)

Ø



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:45pm OVEN TEMPERATURE:
12:15pm FINISH TIME: 320°F

150

QC3- Inspect Part Finish

0.00

BR 10-4-8

(4)

Ø



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 57247

March 31, 2010 10:03:02 AM



Page 3

Item ID: D5957

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Item Name: Saddle, 205

Stop



Start Date: 31/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 57430

0.00



Packaging

Memo

0.00

Packaging

10/04/9 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 *H*

mF 10-4-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:03:07 AM

Page 1

Work Order ID: 57247



Parent Item: D5957



Parent Item Name: Saddle, 205

Start Date: 31/03/2010

Required Date: 09/04/2010

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			110	Each	58.0000	4.0000			



Saddle Billet



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT42 58

41960 1

46412 ✓ 57

4.000 H.A 10/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57247
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.497	0.499	0.497	0.499		
N	1.865	1.885		1.875	1.883	1.876	1.877		
O	7.990	8.010		8.005	8.000	8.000	8.000		
P	2.240	2.260		2.258	2.256	2.259	2.260		
Q	0.308	0.313		0.309	0.310	0.310	0.310		
R	0.760	0.765		0.763	0.763	0.763	0.763		
S	0.490	0.510		0.493	0.500	0.508	0.501		
T	1.625	1.645		1.639	1.632	1.629	1.631		
U	2.000	2.020		2.019	2.000	2.002	2.003		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	K.A	Audited by:	C.M
Date:	10/04/06	Date:	10/04/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED

SUBJECT TO

DART

WITHOUT NOTICE

WORK ORDER

NO. 57247

pt 10-3-31

06.11.28

CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES

R0.250

R1.625

R1.875

0.063

0.500

0.188

R0.063

R0.025

0.313

DETAIL B
SCALE 1:10.033 X 45°
CHAMFER
(2 PLACES)0.760^{+0.005}
-0.000ENGRAVE PART NO.
AND BATCH NO.
WITH MIN RAD OF
0.010 TO MAX
DEPTH OF 0.010

R0.500

Ø0.316
(8 PLACES)DRILL Ø0.316 THRU
Ø0.750 SPOT FACE
(2 PLACES)Ø0.920 SPOT FACE
(2 PLACES)

R0.500

R0.660

Ø0.438
(4 PLACES)**VIEW A-A**

1.750

0.500

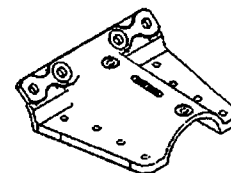
5.250

7.000

8.000

0.040 X 45° CHAMFER
ALL AROUND**D5957 INNER AFT SADDLE****NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957
DATE 06.11.07	TITLE INNER AFT SADDLE	REV. B SHEET 1 OF 1
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
REV B	DATE 06.11.07	DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

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